

**DART**

DESIGN <i>CE</i>	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9348	REV. A SHEET 1 OF 1
DATE 06.08.23	TITLE SKIDTUBE WELD REPAIR		SCALE NTS
A	06.08.23	NEW ISSUE	

## DART SERVICE INSTRUCTION

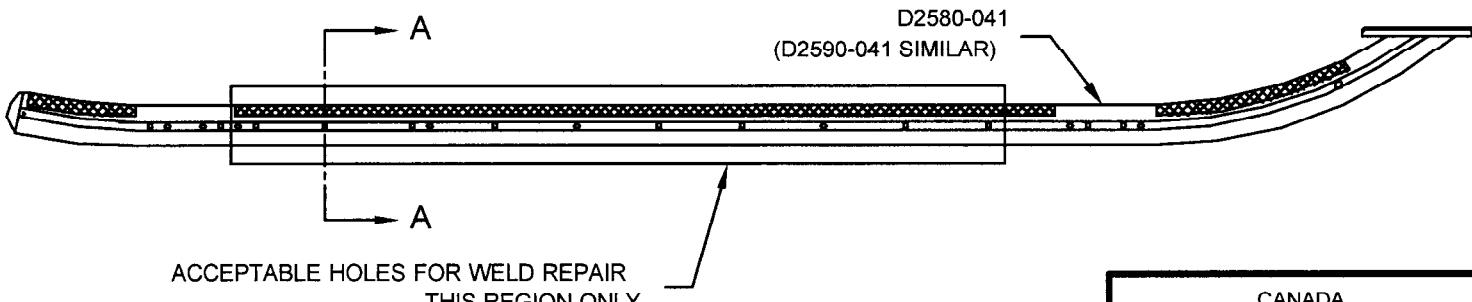
TO AMEND MAINTENANCE MANUAL SUPPLEMENTS MMS-D205-634 REV A OR B AND MMS-D204-635 REV A OR B

REF. CANADIAN STC: SH96-88

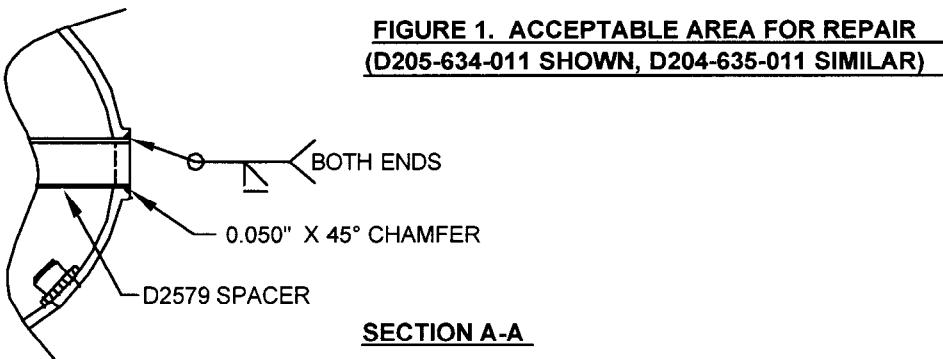
REF. FAA STC SR00563NY

FOR THE D205-634-011 OR D204-635-011 SKIDTUBE INSTALLATION, CRACKS IN THE WELDS AROUND THE HOLES OF THE D2580-041 OR D2590-041 SKIDTUBE ASSEMBLY SHOWN IN FIGURE 1 CAN BE REPAIRED AS FOLLOWS:

- 1) CLEAN AREA OF PAINT, ETC.
- 2) DRILL OUT THE D2579 SPACER USING A Ø0.508" DRILL.
- 3) CHAMFER 0.050" X 45° AROUND THE HOLE ON EACH SIDE OF THE SKIDTUBE. ENSURE THAT ALL REMAINING WELD AROUND THE HOLES IS REMOVED.
- 4) INSERT REPLACEMENT D2579 SPACER.
- 5) T.I.G. WELD CHAMFER PER MIL-STD-2219 / AMS-STD-2219 CLASS 'C' USING 4043 OR 5356 FILLER ROD ON EACH SIDE. DRILL THROUGH SPACER WITH Ø0.386" DRILL (DRILL W) TO REMOVE EXCESS WELD IF NECESSARY.
- 6) BLEND WELDS TO SAME PROFILE AS ORIGINAL PART.
- 7) IF USED FOR GROUND HANDLING, COUNTERBORE BOTH SIDES TO Ø0.437" X 1.00" DEEP AND DEBURR.
- 8) TOUCH UP FINISH IN ACCORDANCE WITH MMS-D205-634 REV A OR B OR MMS-D204-635 REV A OR B.



**FIGURE 1. ACCEPTABLE AREA FOR REPAIR**  
**(D205-634-011 SHOWN, D204-635-011 SIMILAR)**



CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
<b>APPROVED</b> <i>[Signature]</i>	
BY:	D. SHEPHERD (DE # 02)
DATE:	06.08.23
CERT. NO.:	SH96-88
ISSUE NO.:	2

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